

Date: Wednesday, 1/25/2006 2:30:31 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	COVER ASSEMBLY, LH
<b>Job Number</b> :	25625		
<b>Estimate Number</b> :	10401		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3163041
<b>This Issue</b> :	1/25/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3163 REV C
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	23927	<b>Drawing Revision</b> :	C
	<b>Type</b> :	<b>Material</b> :	N/A
	LARGE FAB ASSY	<b>Due Date</b> :	2/1/2006
<b>Written By</b> :	<u>SEE COMMENT BELOW</u>		<b>Qty:</b> 3 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<u>SEE COMMENT BELOW</u>		
<b>Comment</b> :	Est. A05.10.25 New issue KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31631	Plate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Plate

Pick:

Qty	Part Number	Description	Batch
1	D3163-1	Plate	<u>B25022</u>

FF 06-01-24

2.0	D31633	Plate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Plate

Pick:

Qty	Part Number	Description	Batch
1	D3163-3	Plate	<u>B25023</u>

A/R N/A Sikaflex 241/291 M19134  
 Expiry Date: 06-06-20

Bond D3163-3 to D3163-1 using Sikaflex.

Ensure holes line up

FF 06-01-26

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Bond D3163-3 to D3163-1 using Sikaflex. Ensure holes line up

FF 06-01-26

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

Inspect bonding of D3163-1/-3

FF 06-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 1/25/2006 2:30:31 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER ASSEMBLY , LH

Job Number: 25625

Part Number: D3163041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9. m 06-02-09

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

11 06 02 10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

C'sink D3163-3 as per Dwg D3163.

Touch up c'sink holes with alodine.

FF

8.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)-

RIVET

Pick:

Qty

Part Number

Description

Batch

2

MS20426AD3-4

Rivet

M 15786

FF 06-02-15

9.0

MS21059L08

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) :

Nut

Pick:

Qty

Part Number

Description

Batch

1

MS21059L08

Nut Plate

M 10015/m 12706

Assemble nut plate as per Dwg D3163

Identify as D3163-041

FF 06-02-15

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DD Date: 06/02/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/25/2006 2:30:32 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER ASSEMBLY, LH

Job Number: 25625

Part Number: D3163041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify top assembly on the back side of assembly with Dart P/N and B/N using fine point permanent ink marker and Stock

Location:           

CY06102115 3

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5.4.5 06/02/17

(5)

DP

06/02/16

(8)

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries